

Work Order ID 67755

Wednesday, March 30, 2011 10:19:01 AM



Page 1

Item ID: D3651-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

11-03-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3651

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 □ Dwg Rev: B □ Prog Rev: B □ 2-Deburr if necessary

B11-5-11

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-11

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 vides 1/2

(72)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 67755

Page 2

Wednesday, March 30, 2011 10:19:01 AM

Item ID: D3651-11

Accept



Setup Start



Revision ID:

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Item Name: Gasket

Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 188

0.00



Packaging

Memo

0.00

Packaging

11/5/13 SP (2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 (2)
11-08-14 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:20:03 AM

Page 1

Work Order ID: 67755



Parent Item: D3651-11



Parent Item Name: Gasket



Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty. | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|---------------|---------------|----------------|--------|
| G89  coated cloth | | Purchased | No | | | 100 | sf | 0.0000 | 0.686  | 1.444211 | 117666 | B11-512 | |

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | <u>67253</u> |
| Description: Gasket | | Part Number: | D3651-11 |
| Inspection Dwg: D3651 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.129 | +0.005/-0.001 | .134 | X | | V KB02 | |
| Ø0.250 | +0.005/-0.001 | .255 | X | | V | |
| 8.74 | +/-0.030 | 8.74 | P | | PROW302 | |
| 11.62 | +/-0.030 | 11.626 | X | | P | |
| 1.62 | +/-0.030 | 1.617 | X | | V | |
| 1.41 | +/-0.030 | 1.415 | X | | V | |
| 0.500 | +/-0.010 | .501 | X | | V | |
| 0.600 | +/-0.010 | .601 | X | | V | |
| 0.634 | +/-0.010 | .634 | X | | V | |
| 2.564 | +/-0.010 | 2.564 | X | | V | |
| 2.081 | +/-0.010 | 2.081 | X | | V | |
| 3.731 | +/-0.010 | 3.731 | X | | V | |
| 2.100 | +/-0.010 | 2.100 | X | | V | |
| 9.706 | +/-0.010 | 9.706 | X | | P | |
| 7.969 | +/-0.010 | 7.968 | X | | V | |
| 6.96 | +/-0.030 | 6.96 | X | | V | |
| 5.698 | +/-0.010 | 5.698 | X | | V | |
| 3.698 | +/-0.010 | 3.698 | X | | V | |
| 2.564 | +/-0.010 | 2.564 | X | | V | |
| 2.020 | +/-0.010 | 2.020 | X | | V | |
| 3.284 | +/-0.010 | 3.284 | X | | V | |
| 2.200 | +/-0.010 | 2.200 | X | | V | |
| 2.750 | +/-0.010 | 2.750 | X | | V | |
| 9.521 | +/-0.010 | 9.521 | X | | P | |
| 10.22 | +/-0.030 | 10.22 | X | | P | |
| 1.373 | +/-0.010 | 1.373 | X | | V | |
| 1.62 | +/-0.030 | 1.62 | X | | V | |
| 3.564 | +/-0.010 | 3.564 | X | | V | |
| 4.236 | +/-0.010 | 4.236 | X | | V | |
| 5.636 | +/-0.010 | 5.636 | X | | V | |
| 7.049 | +/-0.010 | 7.049 | X | | V | |

| | |
|---------------------|---------|
| Measured by: | B |
| Date: | 11-5-11 |

| | |
|--------------------|----------|
| Audited by: | J |
| Date: | 11/05/12 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| | | | | |
|------------|-------------|---------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | 08.04.17 | New Issue | KJ/DD | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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NOTE: Date & initial all entries

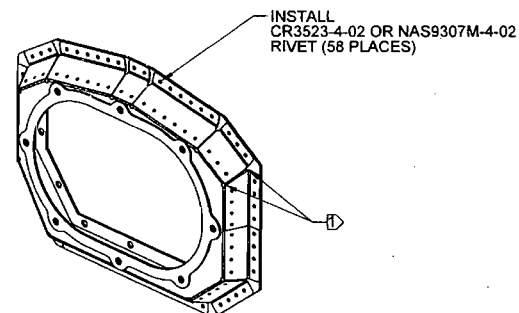
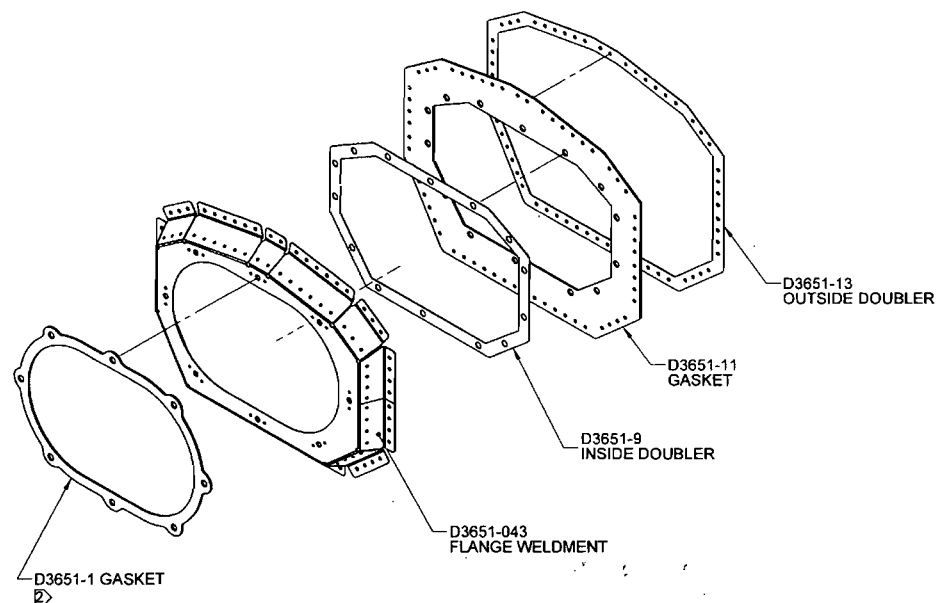
8 7 6 5 4 3 2 1

D

C

B

A



PART LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|------------------------------|-------------------|
| X | D3651-041 | AFT BASE ASSEMBLY |
| 1 | D3651-043 | FLANGE WELDMENT |
| 1 | D3651-1 | GASKET |
| 1 | D3651-9 | INSIDE DOUBLER |
| 1 | D3651-11 | GASKET |
| 1 | D3651-13 | OUTSIDE DOUBLER |
| 58 | CR3523-4-02 or NAS9307M-4-02 | RIVET |

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

RELEASED
08-03-27-14

| | | | |
|--|--|---|----------|
| B | SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504 | RF | 08.01.07 |
| A | NEW ISSUE | RF | 07.11.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. D3651 | |
| CHECKED | RF | REV. B | |
| MFG. APPR. | RF | SHEET 1 OF 9 | |
| APPROVED | RF | TITLE | |
| DE APPR. | RF | AFT BASE ASSEMBLY | |
| DATE | 08.01.07 | SCALE 1:4 | |
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8 7 6 5 4 3 2 1

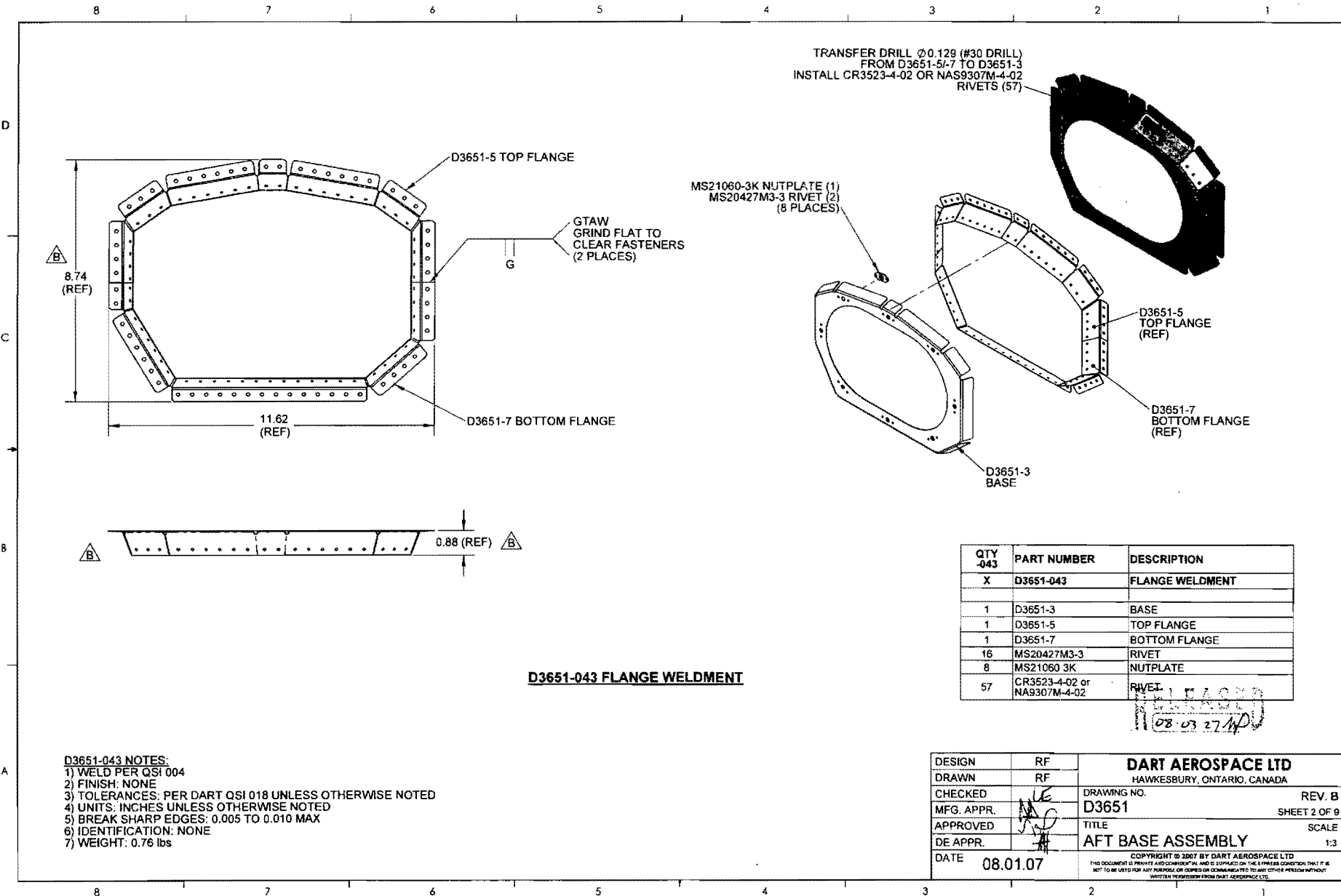
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries



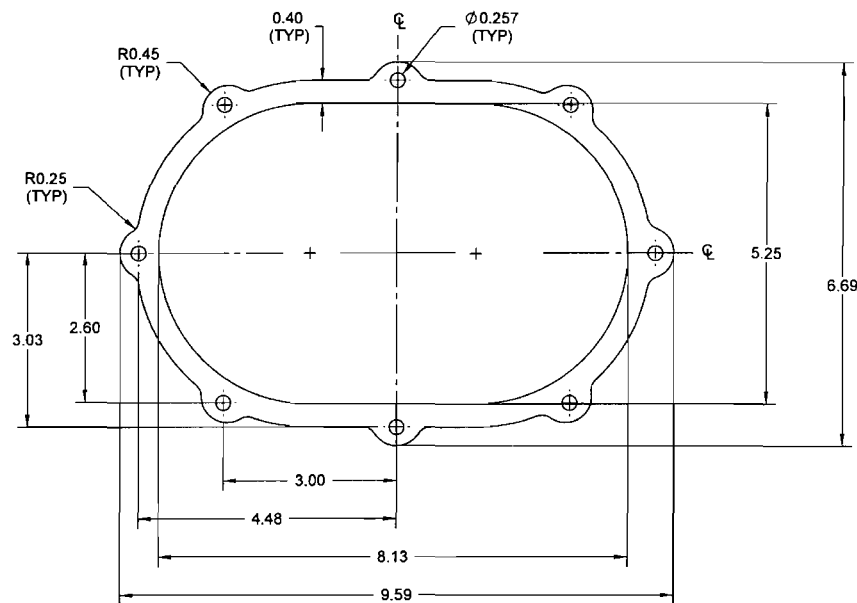
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

| | | | |
|------------|--------------------|--|--------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3651 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 9 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | AFT BASE ASSEMBLY | 1:2 |
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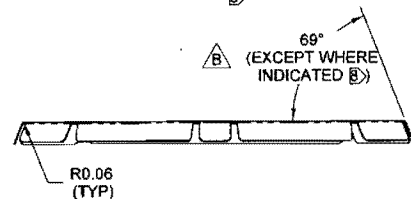
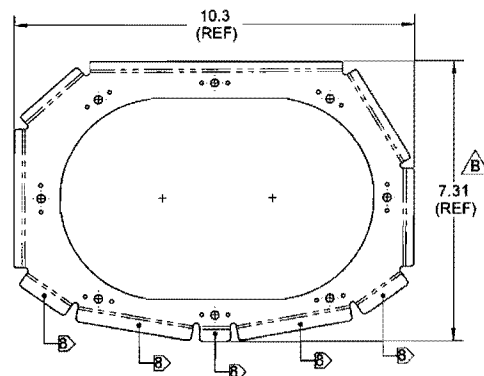
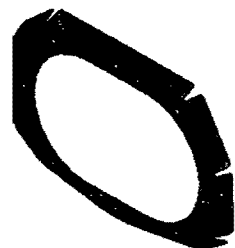
| W/O: | | WORK ORDER CHANGES | | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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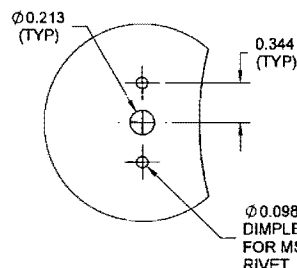
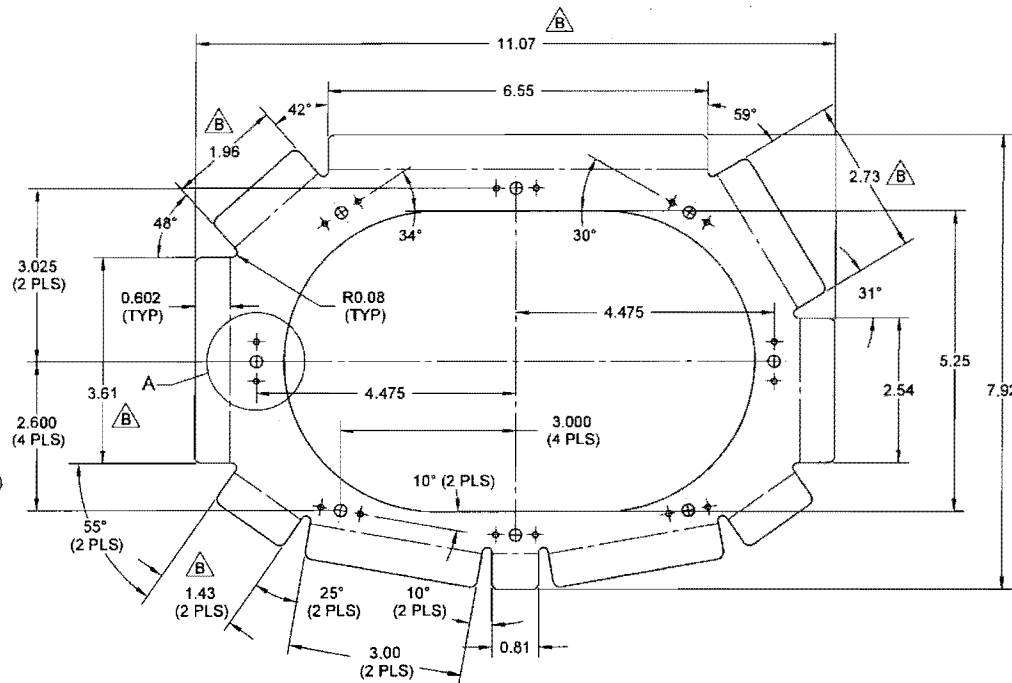
NOTE: Date & initial all entries



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

| | | | |
|------------|----------|--|--------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | KE | DRAWING NO. D3651 | REV. B |
| MFG. APPR. | W | SHEET 4 OF 9 | |
| APPROVED | W | TITLE | SCALE |
| DE APPR. | W | AFT BASE ASSEMBLY | 1:2 |
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Dart Aerospace Ltd

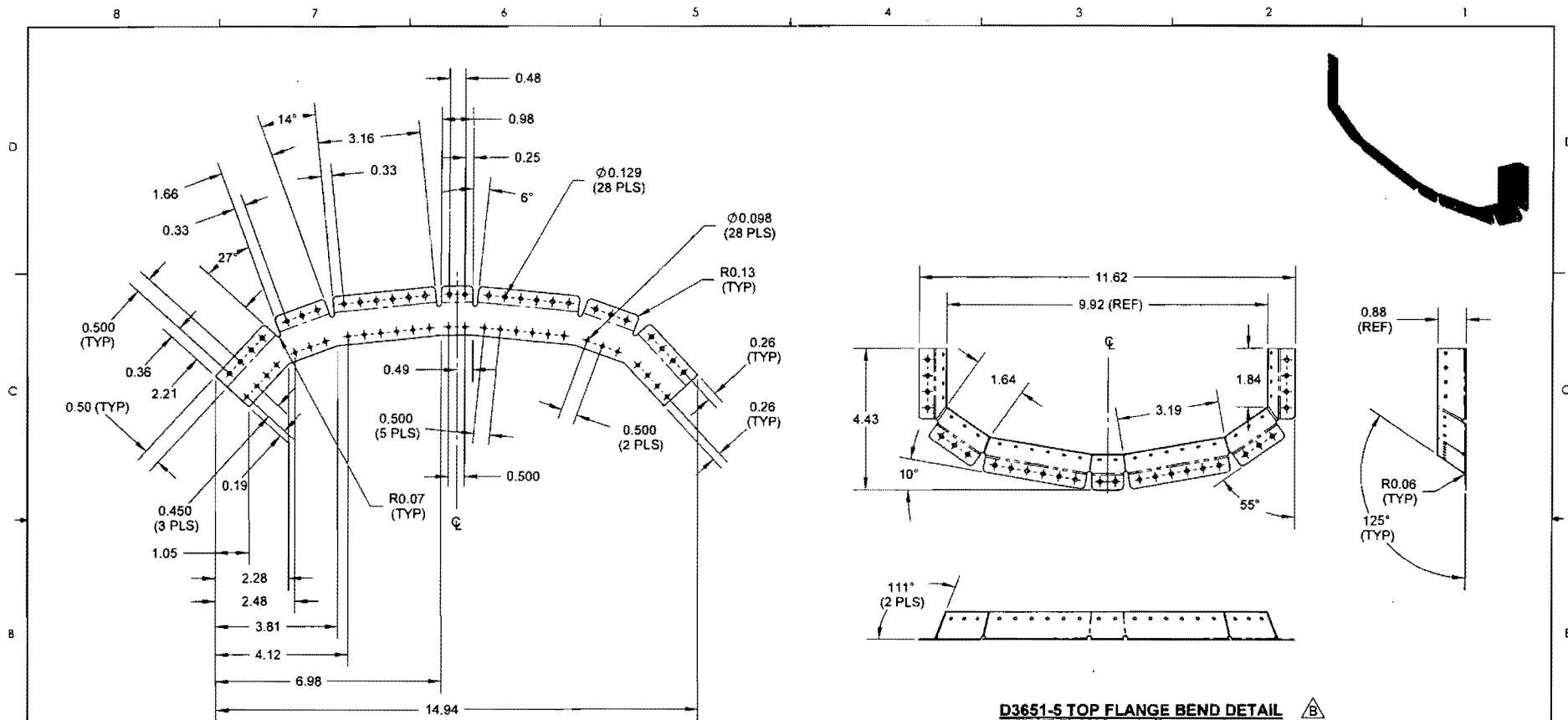
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3651-5F FLAT PATTERN

D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

| | | | |
|------------|-----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>RF</i> | D3651 | SHEET 5 OF 9 |
| APPROVED | <i>RF</i> | TITLE | SCALE |
| DE APPR. | <i>RF</i> | AFT BASE ASSEMBLY | |
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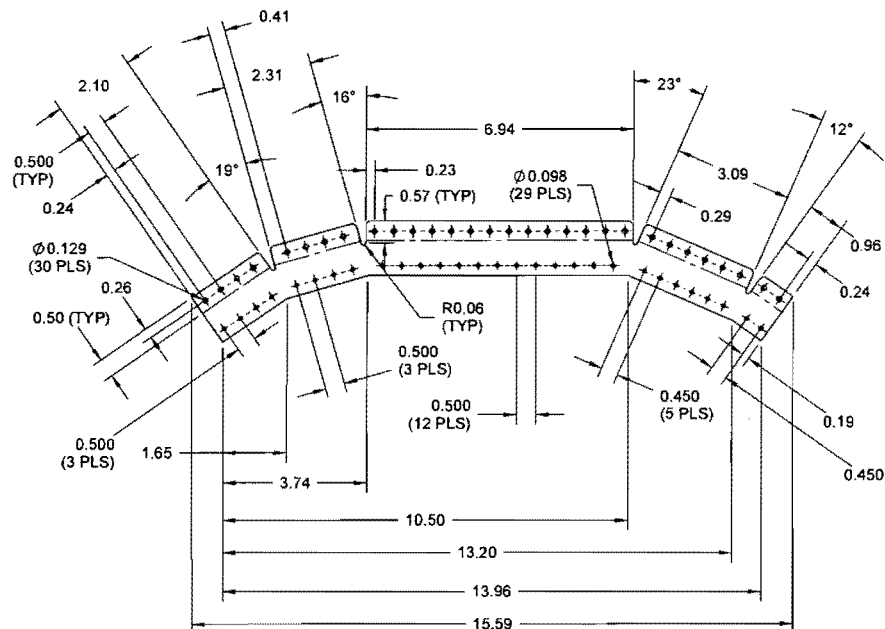
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

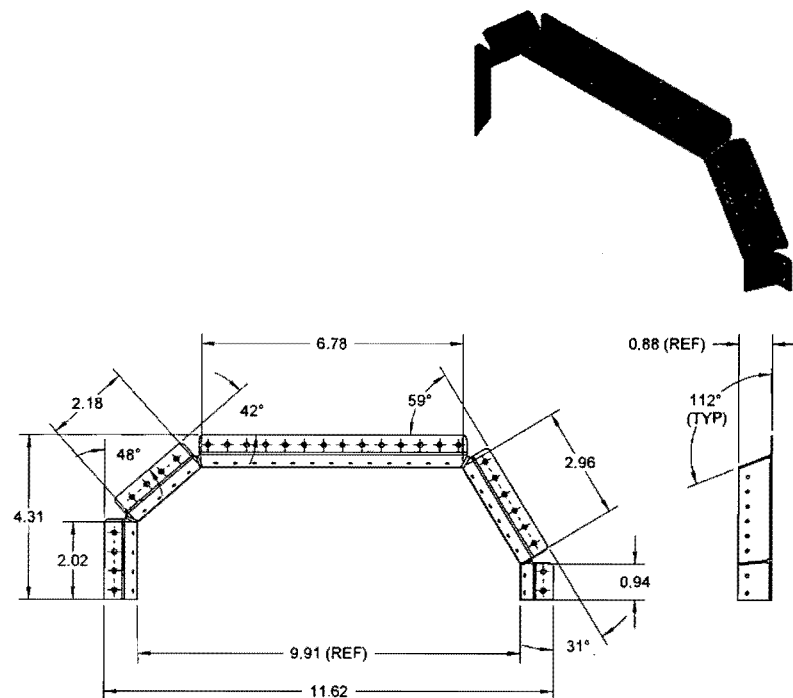
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries






D3651-7F FLAT PATTERN



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

| | | | |
|--|---|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | NE | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3651 | SHEET 6 OF 9 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | AFT BASE ASSEMBLY | 1:3 |
| DATE | 08.01.07 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
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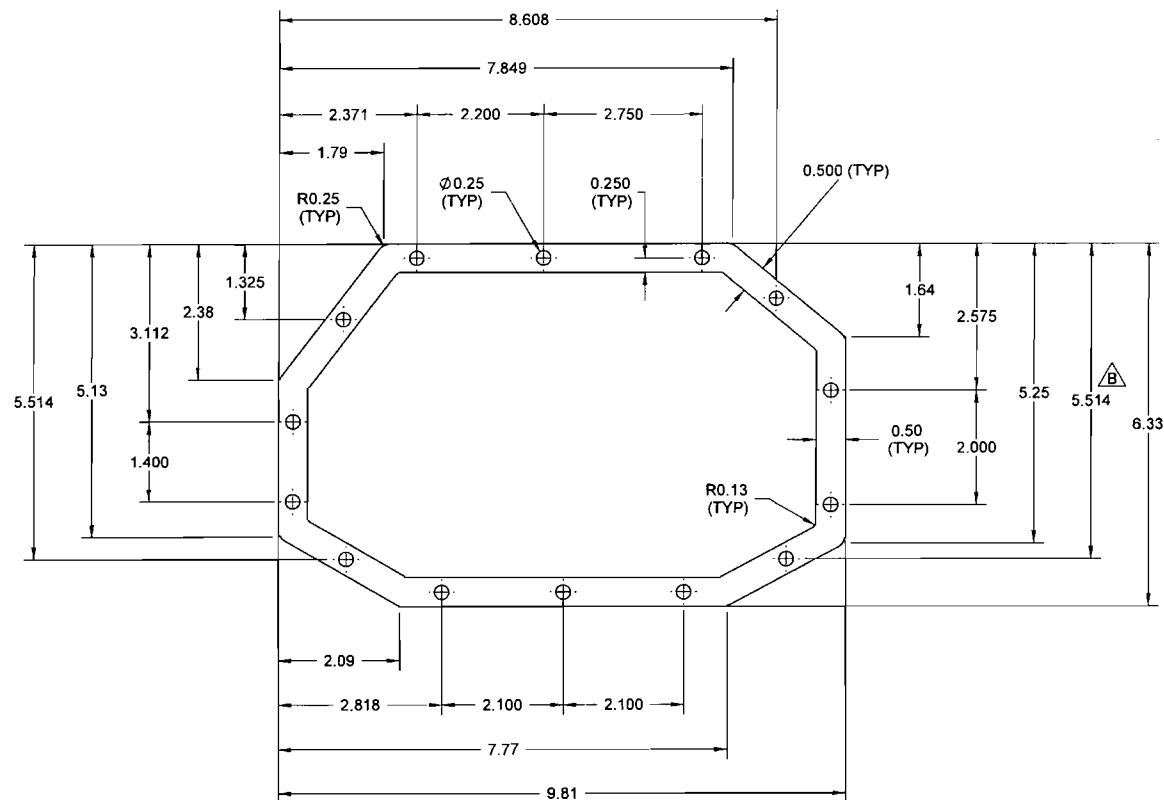
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | WLE | DRAWING NO. | REV. B |
| MFG. APPR. | WLE | D3651 | SHEET 7 OF 9 |
| APPROVED | WLE | TITLE | SCALE |
| DE APPR. | WLE | AFT BASE ASSEMBLY | 1:2 |
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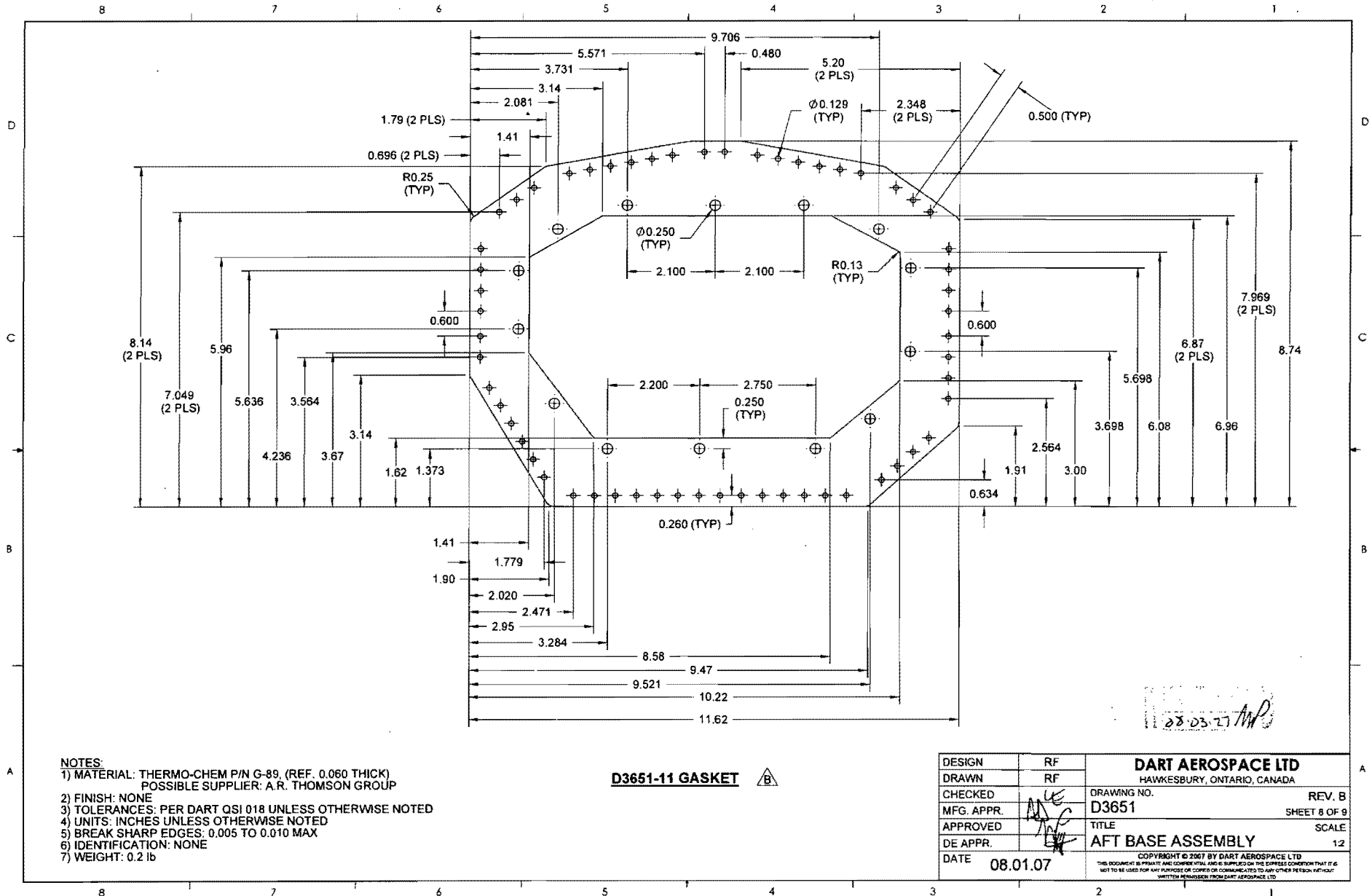
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



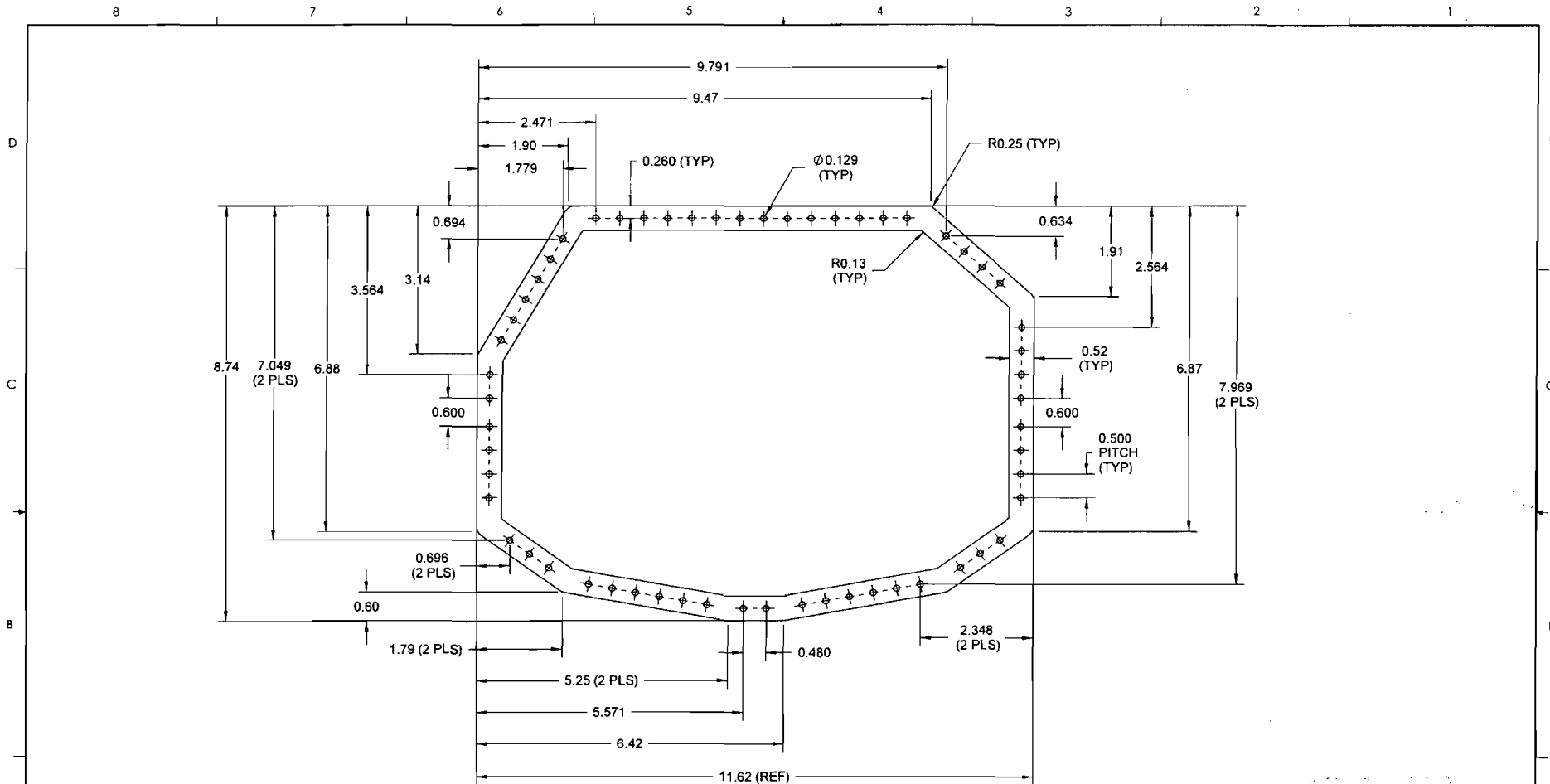
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D3651-13 OUTSIDE DOUBLER B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3651 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 9 OF 9 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | AFT BASE ASSEMBLY | 1:2 |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries